



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G13231-3G**Job Sheet 191252****Part No:** RBW6205G13231-3G**Job Qty:** 9 pcs**Part Name:** Arm Assembly**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/25/19**Job Tracking No:****Due Date:** 4/29/19**Created By:** Patrick Lussier**Type:** Stock**Description:****Note:** DWG RBW6205G13231-3G REV 1 IPP REV A 18.02.16 NEW ISSUE FK VERIFY DP**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	9 pcs	4/29/19	4/29/19	0.00	0.00	Purchasing - 1		APR 01 2019
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	9 pcs	4/29/19	4/29/19	0.00	0.00	Packaging 2 - 1 - B4B		APR 01 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		



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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S167981**Part:** RBW6205G13231-3G**Job No:** 191252**Serial No/Batch:** S167981**Revision:** 1**Inspector:****Exp Date:****Instructions:****Date:** 04/01/19

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					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					QC 6 - 42	
					QC 6 - 9	
120 QC 6	9 pcs	4/29/19	0.00 0.00	QC 6 - 68		DAS
				QC 6 - 61		APR 03 2019 68
						9-89
130 Packaging 3-1 - Stock - B4B	9 pcs	4/29/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		DAS
				Packaging 3 - 7 - B4B		28
				Packaging 3 - 8 - B4B		9-89
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
140 QC 21 - SA	9 pcs	4/29/19	0.00 0.00	QC 21 - SA - 21		DAS
				QC 21 - SA - 70		21
				QC 21 - SA - 53		9-89

Part Op **100** - (Purchasing) 1- Issue P/O to Arrow Tech Machine Works P/O# _____ 2- Manufacture
 Descriptions: RBW6205G13231-3G as per DWG 3- Certificate of conformity is required
110 - (Receive & Inspect for Damage & Mat'l Certs)
120 - (QC6- All purchased or subcontracted products)
130 - (Identify as per dwg & Stock Location: _____)
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6205G13231-3GP	Arm Assembly	9 Ea (1 ea)	100-Purchasing	5167980

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6205G13231-3GP	9	0	0

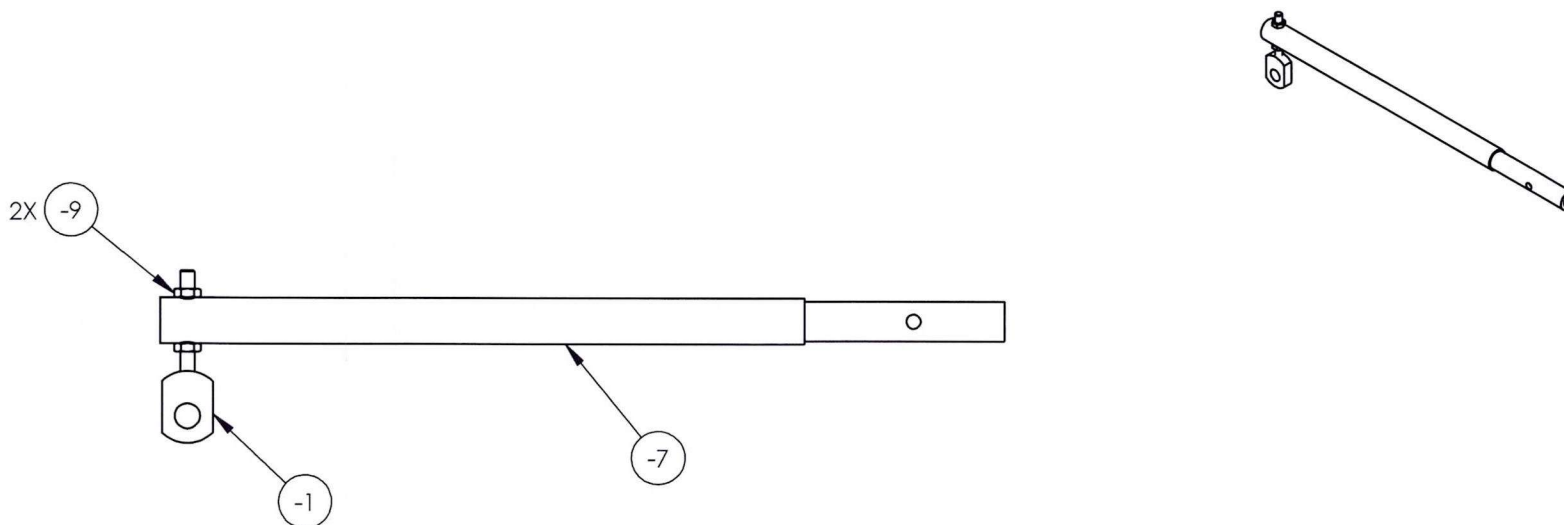
Part Specifications

Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		-1 DELETED ENGRAVE NOTE. -3 ADDED ENGRAVE NOTE. -7 ADDED ENGRAVE NOTE. -9 CH'D WAS 5/16-18 #93839A030 IS 5/16-24 UNF #93839A810.	1/19/2011	RJC	RW
B		-3 CH'D ENGRAVE NOTE WAS RBW6205G13451 IS RBW6205G13231-3G.	4/15/2013	CFS	RW
1	15-0152	-1 CH'D QTY WAS 3 IS 1, CH'D WELD WAS SILVER SOLDER IS TIG. CH'D MATERIAL CALL OUT WAS 1018 IS 1018/1020. -7 CH'D DIM WAS Ø.500 IS Ø.50.	7/1/2015	RJC	JAG



NOTES:

- REF. AGUSTA T/N: 3G6205G13231-3G.
- PART OF KITS RBW6205G11231-3G AND RBW6205G13831-3G.

DART AEROSPACE	
TITLE ARM ASSEMBLY	
DWG NO. RBW6205G13231-3G	REV 1
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: CLOUGH APPROVED <i>D. Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AGUSTA
SCALE 1:4	DATE 4/30/2010 SHEET 1 OF 5

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	ADJUSTER WELDMENT			2
	1		-3		LINK	1018/1020		3
	1		-5		STUD	STEEL	5/16-24 (MCMASTER-CARR #98791A030) MODIFIED	4
			-7	1	TUBE	6061		5
		B/O	-9	2	THIN HEX NUT	STEEL	5-16-24 UNF (MCMASTER-CARR #93839A810)	1
ASSY #	ASSY -1							



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PURCHASE ORDER

PO042703



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO042703
PO Date: 2/25/19
Due Date: 4/29/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To:

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	191247	RBW6305G01232-3GP			Gimbal Torque Tube Bushing Remover REV 3	Firmed	-	4/29/19	2 Ea	0 Ea	2 Ea	\$708.34/Ea	\$1,416.68
2	191252	RBW6205G13231-3GP			Arm Assembly As Per Dwg RBW6205G13231-3G Rev. 1	Firmed	-	4/29/19	9 Ea	0 Ea	9 Ea	\$298.00/Ea	\$2,682.00
3	191253	RBW6305G00232-3GP			Gimbal Torque Tube Bushing Installer REV 2	Firmed	-	4/29/19	2 Ea	0 Ea	2 Ea	\$708.75/Ea	\$1,417.50
4	191255	RBW6205G06131-3GP			Main Rotor Pitch Control Lever Expander REV D	Firmed	-	4/29/19	4 pcs	0 pcs	4 pcs	\$913.63/pcs	\$3,654.52
5	191258	RBW6205G03731-3GP			Trim Tab Bending Gauge Assembly REV 4	Firmed	-	4/29/19	3 Ea	0 Ea	3 Ea	\$1,204.00/Ea	\$3,612.00

Grand Total: \$12,782.70

413.50
115.50
1039.50

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PURCHASE ORDER

PO042703



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

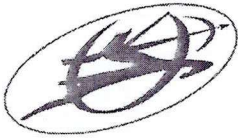
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

A handwritten signature in black ink, appearing to be "P. Lussier".

Plex 2/25/19 2:20 PM dart.Lussier.Patrick



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 491

Date: 3/28/2019
PO Ref: 042703
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

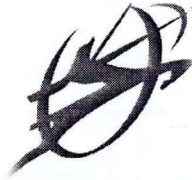
Qty	Item	Part No.
9 ✓	ARM ASSEMBLY	✓ RBW6205G13231-3G
4 ✓	M/R PITCH CONTROL LEVER EXPANDER	✓ RBW6205G06131-3G ✓
2 ✓	GIMBAL TORQUE TUBE BUSHING INSTALLER	✓ RBW6305G00232-3G
2 ✓	GIMBAL TORQUE TUBE BUSHING REMOVER	✓ RBW6305G01232-3G

Received by: _____

Packaged by: J.M.L

Checked by: AdP

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No:042703 ✓

Dated: 3/28/2019

Our Order / Job No:042703-2AWT

Order Qty: 9 ✓

Part Name: ARM ASSEMBLY

Part Number: RBW6205G13231-3G ✓

Lot Size: N/A Ship Date: 3/28/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number:RBW6205G13231-3G

Rev:1

Material Size and Type: -3/1018 STEEL; -7/6061 ALUM.

Material Specifications: STEEL: ASTM A108; ALUM.: ASTM B221

Heat Treatment: N/A

Plating/Finish: CLEAR ANODIZE: MIL-A-8625F, TYPE II, CLASS I; ZINC PLATE: ASTM B633 TYPE 1, SC2

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 03/28/19

Signed: _____


DAS
68
9-89

PHGE Machine Works LLC dba Arrow Tech Machine Works
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